

Date: Tuesday, 7/17/2007 2:02:02 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ACCESS PANEL		
Job Number	: 33605					
Estimate Number	: 12500					
P.O. Number	: N/A		Part Number	: D32551		
This Issue	: 7/17/2007 S.O. No. : N/A		Drawing Number	: D3255 REV B		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: 28837		Material	: N/A		
Written By			Due Date	: 8/24/2007 Qty: 4 Um: Each		
Checked & Approved By						
Comment	: Est Rev:A New Issue 06-08-01 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S22GA	304/316 .032 Sheet
Comment: Qty.: 1.5582 sf(s)/Unit Total : 6.2328 sf(s) 304/316 .032 Sheet (M304S032) Batch: M105061 HB 07-08-05		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3255 Dwg Rev: B HB 07-08-05 Prog Rev: B		
2-Deburr if necessary <div style="text-align: right;">SAO 0710869</div>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <div style="text-align: right;">HB 07-08-05</div>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <div style="text-align: right;">En 07/08/05 X4</div>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Form as per Dwg D3255 <div style="text-align: right;">FF 07-09-27 4</div>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:02:02 PM
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Process Sheet

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Drawing Name: ACCESS PANEL

Job Number: 33605

Part Number: D32551

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



En 07/09/2008

(X4)

center

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WALC001

Lc 7/9/28 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

120709108

Job Completion



U 07/09/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33605
Description: Access Panel Assembly	Part Number:	D3255-1
Inspection Dwg: D3255 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

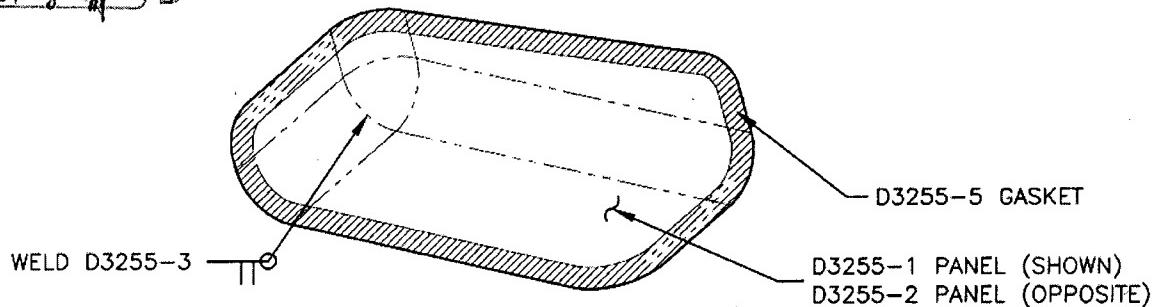
Measured by:	<u>LR</u>	Audited by:	<u>Er</u>	Prototype Approval:	N/A
Date:	07-08-05	Date:	07/08/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	

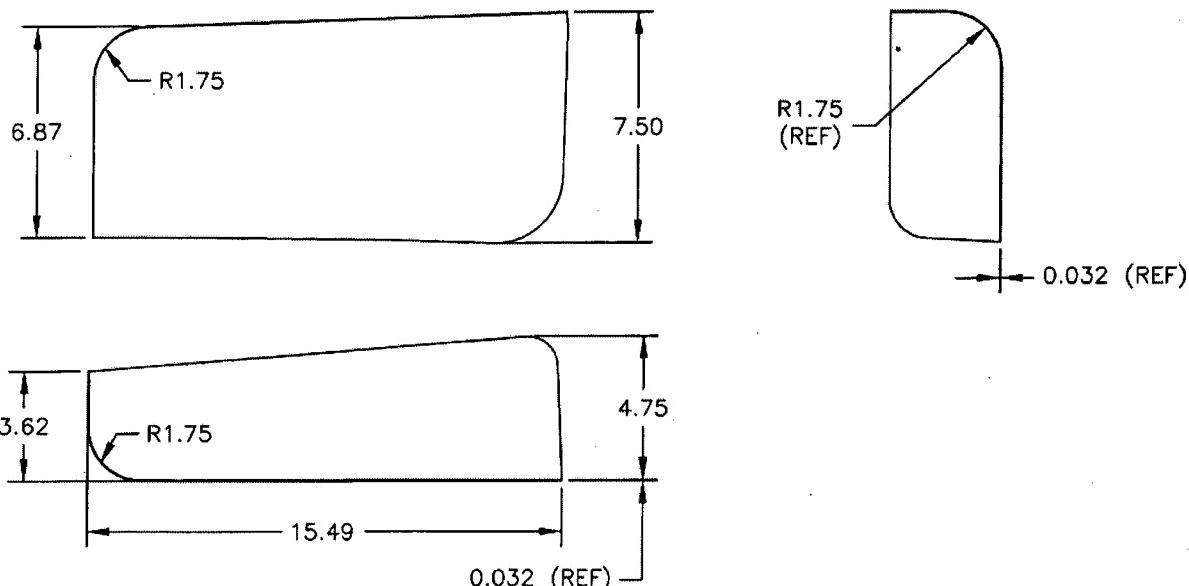


DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ip</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05.01.18 *[Signature]*



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

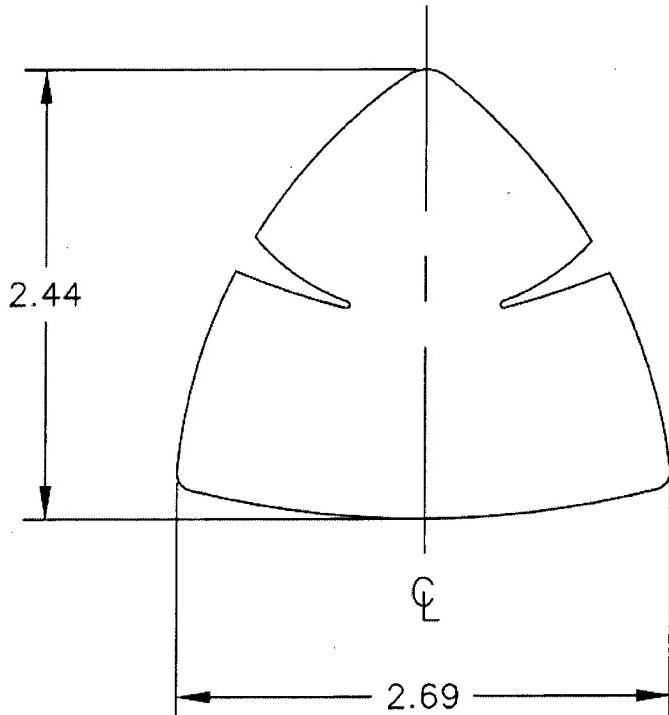
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *33605*



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P	APPROVED <i>[Signature]</i>	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE	SCALE 1:1

RELEASED
05.01.18 *[Signature]*



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT

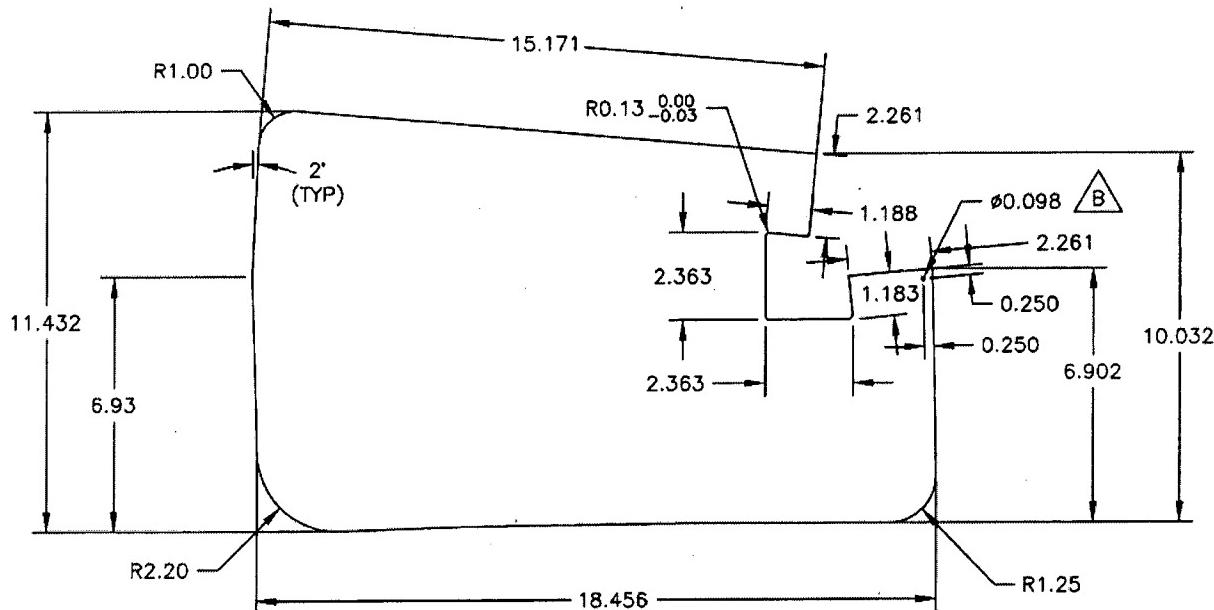
WITHOUT NOTICE

WORK ORDER

NO. *33605*

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>GP</i>	APPROVED <i>RF</i>	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18**D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

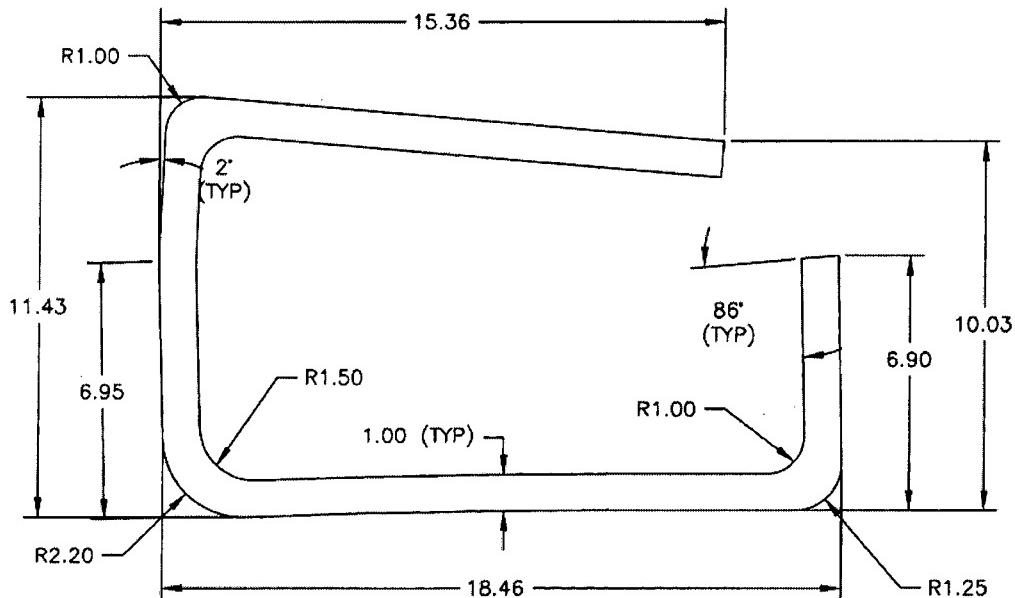
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE
WORK ORDER
NO. *33605*



DESIGN <i>JF</i>	DRAWN BY <i>JF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>JF</i>	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06	TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5	

RELEASED
05.01.18 *JF*



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

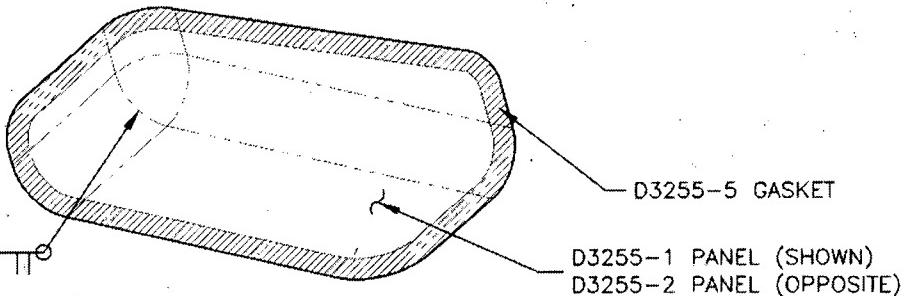
WORK ORDER
NO. 33605

DART

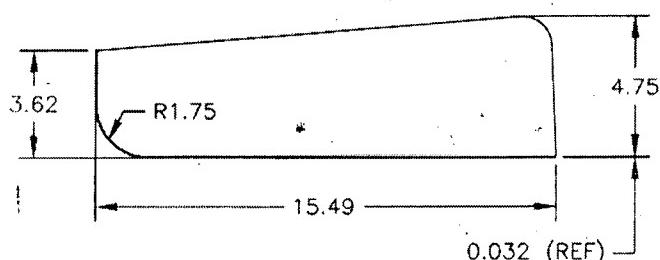
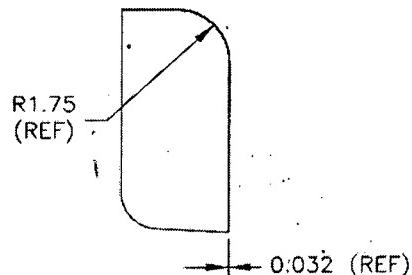
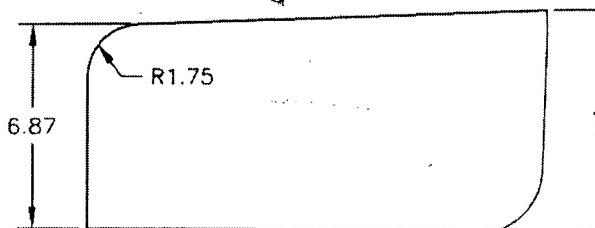
DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ip</i>	APPROVED <i>SH</i>	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05.01.18 *ff*

WELD D3255-3



**D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL
D3255-2 OPPOSITE**

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER